

Work Order ID 72248

Wednesday, July 20, 2011 9:50:15 AM



Page 1

Item ID: D2873-043	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Nut Plate Assembly					
Start Date: 7/20/2011	Start Qty: 20.00		Cust Item ID:		
Required Date: 8/4/2011	Req'd Qty: 20.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 11-07-20	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2873	Rev A								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 3.700" long		SL 11-07-25			20			

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-3		SL 11-07-25			20	0		
	Dwg Rev A Folio Rev AA								

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control			SL 11-07-25			20	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

H.A 11/07/25

20

0



QC

Memo

0.00

Quality Control

140

Small Fab

0.00

SPB 11/07/27

20



Small Fab

Memo

0.00

Small Fab

1-Deburr ☐ 2- C'sink as per Dwg D2873

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 27 20

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20 11-7-22

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 11/07/22

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 02-Identify as D2873-043

20 11/07/22

20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 4

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 28 (20)

200

Identify as per dwg & Stock Location: *xtake assy*

0.00



Packaging

Memo

0.00

Packaging

11-07-28 (20)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/28
11-07-28
20

Dart Aerospace Ltd

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Picklist Print

Wednesday, July 20, 2011 9:50:21 AM

Page 1

Work Order ID: 72248

Parent Item: D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 7/20/2011


Required Date: 8/4/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21075L5		Purchased	No			100	Each	126.0000	3	60			
													
Nut Plate													

Location	Loc Qty	Loc Code
ST302	125	
118267	125	
ST303	1	
116914	1	

SB 11/67/28


60

M6061T6B0.375X01.00		Purchased	No			180	f	11.4366	0.3083	6.490526			
0													
													
6061T6 BAR .375 x 1.00													

Location	Loc Qty	Loc Code
MAT002	11.4366	
116963	2.6766	
117653	8.76	

SL 11-07-25

6.5

MS20426AD4-6		Purchased	No			180	Each	1,049.000	6	120			
													
Rivet													

Location	Loc Qty	Loc Code
ST317	1049	
110139	555	
117505	494	

SB 11/67/28

120

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 72248
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	/		Vern. SL-3	
2.000	+/-0.010	2.000	/			
0.750	+/-0.010	.750	/			
1.000	+/-0.010	1.000	/			
0.250	+/-0.010	.250	/			
1.000	+/-0.010	1.000	/			
2.000	+/-0.010	2.000	/			
3.000	+/-0.010	3.000	/			
Ø0.128	+0.005/-0.001	.129	/			
0.359	+/-0.010	.359	/			
Ø0.316	+0.006/-0.001	.314	/			
1.000	+/-0.010	1.004	/			
0.250	+/-0.010	.250	/			
0.061	+/-0.010	.062	/			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Box-126	/			

Measured by: SL
Date: 11-07-25

Audited by: B.A
Date: 11/07/25

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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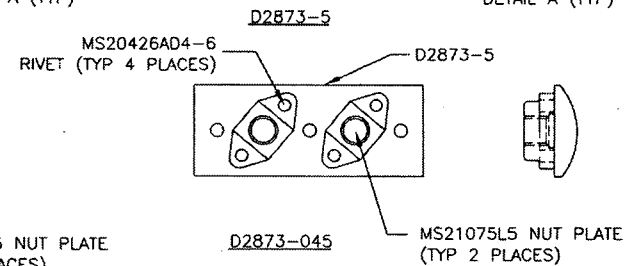
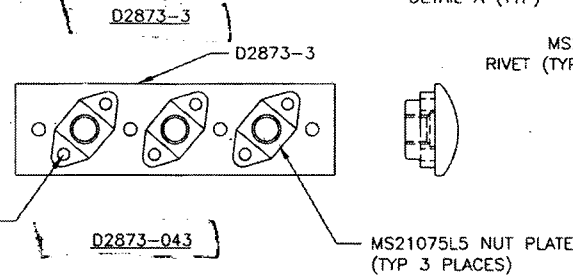
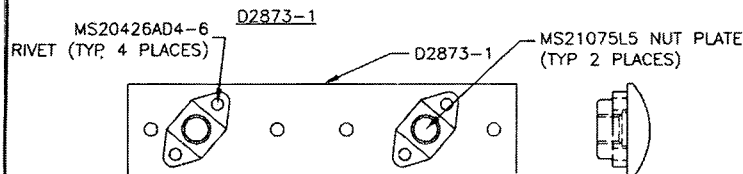
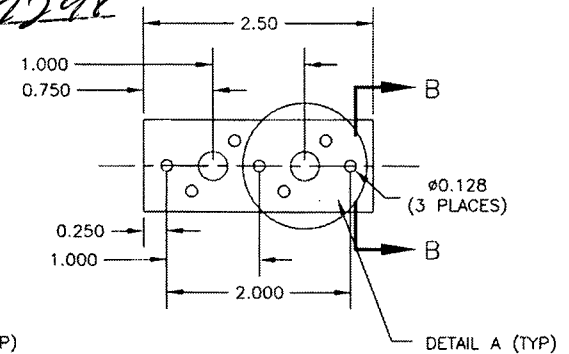
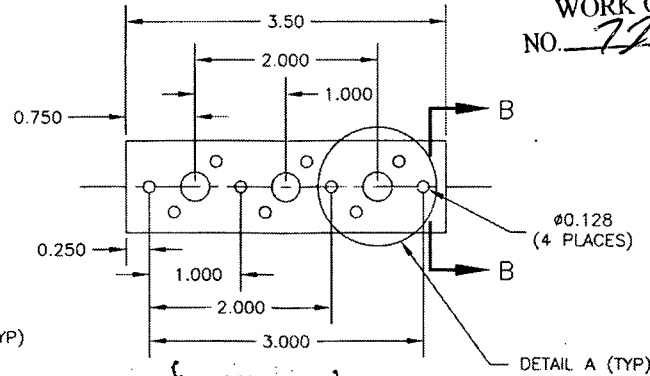
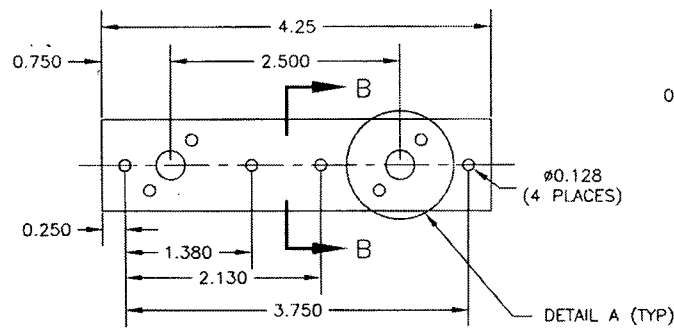
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 72248



D2873-041

MS20426AD4-6
RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE
(TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE
(TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

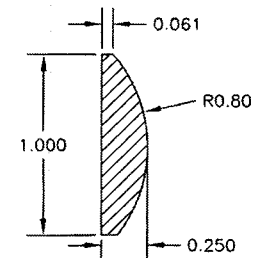
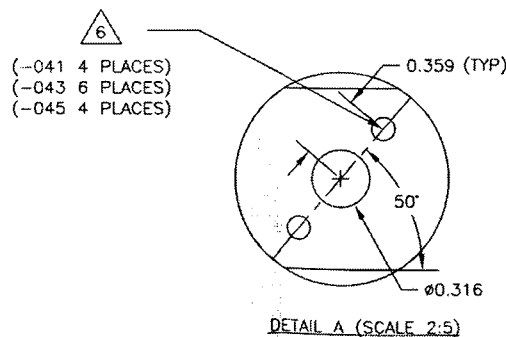
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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